					-						
	er ID 68706 il 20, 2011 8:35:03 AM									Page 1	
Item ID: Revision ID:	D3437-043		Accept				Setup				
Item Name:	Aft Strut Assembly							Stop			
Start Date:	4/20/2011 Start Qty: 4.00		•	Cust Item []	D:						
Required Date:	4/25/2011 Req'd Qty: 4.00			Customer:							
Reference:	,								: : : : : : :		
Approvals:	Process Plan:	Date://-04-30	✓Tooling:	Da	te:	_	Run	Start			
	QC:	Date:	SPC (Y/N):	Da	ite:	_		Stop /			
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code		t Rej Qty	•	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										•
D3437	Rev B								7		_
100	Small Fab		0.00			2	5.,,	/25	/23	(4))
Small Fab	Memo		3 0.00		ST.		21/				
Small Fab	Assembl	le as per Dwg D3437Dwg Rev:			/						
110	QC4- 100% Inspect	kits for completeness	0.00				_				
			2 111	orto		(71	4 J				
QC Quality Control	Memo		0.00	0,107							
Quality Control										\wedge	

120

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

	•								
W/O:			W	ORK ORDER CHANG	GES	***************************************			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,									
Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	s No	DQA:	Date: _	
	Re	solution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			ction B	Ve	erification	Approvat	Approvai
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		Section C	Chief Eng	QC Inspector
				·					

Work Order ID 68706

Wednesday, April 20, 2011 8:35:03 AM



Page 2

Item 1D:

D3437-043

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 4/25/2011

Aft Strut Assembly

Start Date:

4/20/2011

QC:

Start Qty: 4.00

Req'd Qty: 4.00

Operation

Description

Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run Start

Stop



Sequence ID/

Work Center ID

130

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Quality Control

	-									
W/O:	-		W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE	В	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·								
Part No		PAR #:	Fault Cate	egory:	NCR:	Yes N	o DQ	4 :	Date: _	
	R	esolution:	Disposition	n:	QA: N	/C Clos	sed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	IANCE (I	NCR)				
DATE	Description of NC		Corrective Action Section B				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Picklist Print

Wednesday, April 20, 2011 8:35:10 AM

Work Order ID: 68706

D3437-043

Parent Item Name: Aft Strut Assembly

Parent Item:



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00 Required Qty: 4.00

Comments: II	PP A□05.05.20	□New Issue□KJ/	JLM□										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516		Purchased	No			100	Each	55.0000		* \$511	65	/03	
				Location	!	Loc	<u>Otv</u>	Loc Code		-			
•				ST347	102842		55 55	٠		8	-		
03437-1 		Manufactured	No			100	Each	16.0000	1	4	Sujos	-/o3	
				Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code					
				ST508			16				-		
					44787		4			_3	_		
					46046		12						
03437-3 		Manufactured	No			100	Each	42.0000		4	11/05	103	
•				Location	<u>!</u>	Loc	<u>Otv</u>	Loc Code			•	•	
				ST508			42		_				
					43175		42			4			
D3437-9 		Manufactured	No			100	Each	11.0000		4	Sufo	5/03	?
				Location	<u>l</u>	Loc	Qty	Loc Code		//		•	
				ST508			11		**************************************		_		•
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					44790		8		_	$_{\sim}$			

Page 1

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W/O:			W	ORK ORDER CHANG	BES	-				
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		÷			٠					
Dart Na	_	DAD #:	Fault Cat		NO	3. V	No. DO	<u> </u>	Dete	
Part No		PAR #:								
	Re	esolution:							Date:	
NCR:		· ·	WORK ORI	DER NON-CONFORM	ANCE	: (NCH	(i)			
DATE	STEP	Description of NC			tion B	Ciam 0		cation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector

Picklist Print

Wednesday, April 20, 2011 8:35:10 AM

Page 2

Work Order ID: 68706

Parent Item:

D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5



Purchased

No

100

Each

558.0000

Loc Code

Location	Loc Qty
FG	20
101418	20
ST301	538
112314	438
116548	100

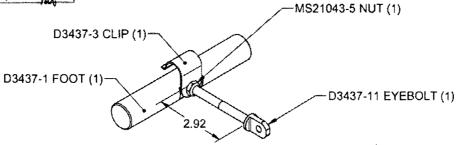


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W/O:			WC	RK ORDER CHANC	GES			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		e e						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _	
	Re	solution:	Disposition	1;	QA: N/C Clo	osed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR)		
D.4TE	0==0	Description of NC			ction B	Verificatio	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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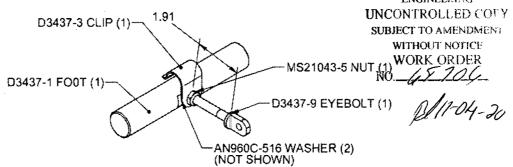
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		THE .	- All	D3437	SHEET 1 OF 4
	DATE		•	TITLE	SCALE
		05.0)8. 1 1	AFT STRUT ASSEMBLY	1:2
٠	Α	0:	5.04.29	NEW ISSUE	
	В	0:	5.08.11	UPDATE D3437-5/-9/-11 DIMENSION	vs

RELEASED 05.08.16

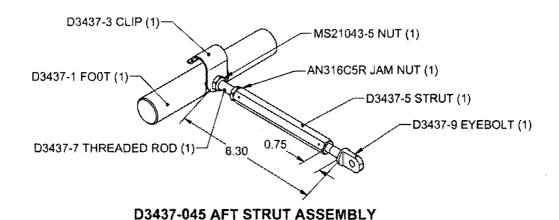


D3437-041 AFT STRUT ASSEMBLY

SHOP COPY-RETURN TO ENGINEERING



D3437-043 AFT STRUT ASSEMBLY



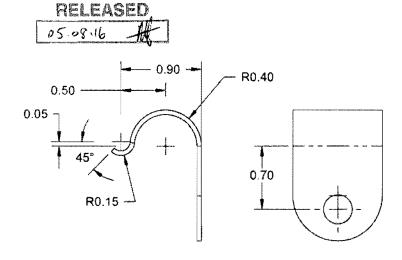
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

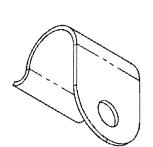
W/O:	-		W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		*							
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	l)			
DATE	0755	Description of NC	Description of NC Corrective Action Se			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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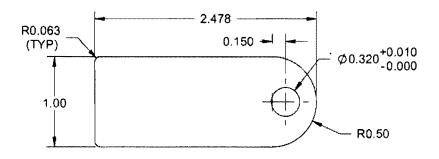
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DATE		TITLE	SCALE				
05.0	8.11	AFT STRUT ASSEMBLY	1:2				





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D3437-3 CLIP SCALE 1:1



D3437-3 FLAT PATTERN

D3437-3 CLIP:

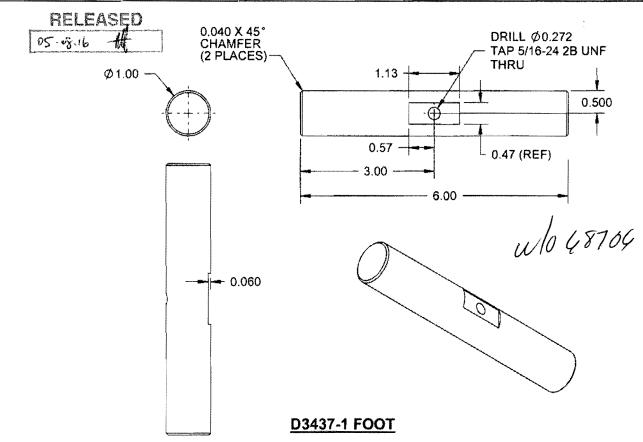
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	Ву		Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Description of NC Section A Initial Action Descriptio				Verificat	ion	Approval	Approval
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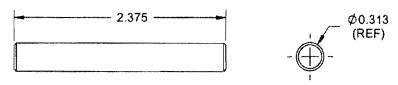


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CHECKED	APPROVED 4	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
05.0)8.11	AFT STRUT ASSEMBLY	1:2



D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

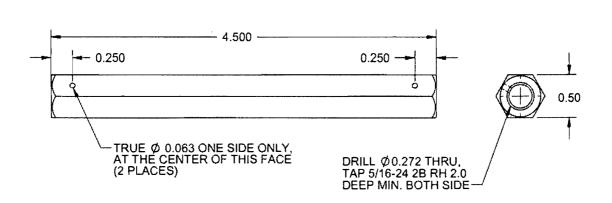
- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAUR P/N 870-832 18-8 5/16-24 SS THREADED ROD 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
		esolution:							
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector



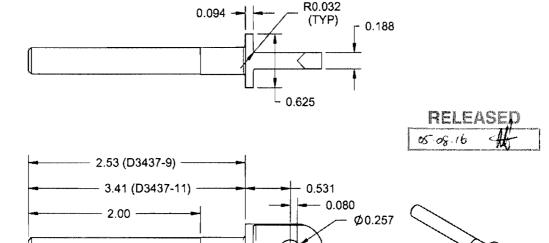
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05.0	08.11	AFT STRUT ASSEMBLY	1:2			



D3437-5 STRUT:

1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010





R0.31

D3437-9/-11 EYEBOLT:

5/16-24 2B THREAD

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:			M	ORK ORDER CHANGE	S				
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DATE	STEP	P Description of NC Section A	Corrective Action Section B			Verifi	cation	Approval	Approval
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